Work Order ID 110524

December-23-13 11:48:03 AM

110524 PRELIMINARY ISSUE

Item ID: D4950-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Plate

Start Date: 12/23/13 **Start Qty:** 1.00 *1*

Required Date: 12/27/13 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 13-12-23 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4950	**Revision Nbr** ~~pb2~~ Rev B	DAS 10 ~~9-89~~							
100	FLOW WATER JET	0.00							
100 Waterjet	**Memo**	0.00				3	Q	13-12-27	
FLOW CNC Waterjet	1-Cut as per Dwg D4950 Dwg Rev: PB2 Prog Rev: PB2 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC	**Memo**	0.00				3	Q	13-12-27	
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120 QC	**Memo**	0.00	DAS 27 ~~9-89~~ 14/1/17			3			
Quality Control						Inspect as Per Dwg PB2			

Work Order ID 110524

110524

December-23-13 11:48:03 AM

Item ID: D4950-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Plate

Start Date: 12/23/13 **Start Qty:** 1.00 *1*

Required Date: 12/27/13 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					3			9/04/07
Small Fab	**Memo**	0.00	DAS 30						
Small Fab	1- deburr 2- form as per dwg D4950								
140	QC5- Inspect part completeness to step on W/O	0.00	DAS 27 9-89						
140			14/1/17			3			
QC	**Memo**	0.00							
Quality Control						Inspect as per Dwg pb2			
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	**Memo**	0.00							
Hand Finishing	N/A								

Work Order ID 110524

December-23-13 11:48:03 AM

110524

Item ID: D4950-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Plate

Start Date: 12/23/13 **Start Qty:** 1.00 *1*
Required Date: 12/27/13 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location:_____	0.00							
170									
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	**Memo**	0.00							
Quality Control									

14/2/6 (3)

14-01-23

POSITIVE RECALL
EFFECTIVE 13.12.23 AUTH
RELEASED S DATE 14/01/22
to Rev B Drawing

14-01-07

Picklist Print

December-23-13 11:48:02 AM

Work Order ID: **110524**

Parent Item: **D4950-1** **Start Date:** 12/23/13 **Required Date:** 12/27/13

Parent Item Name: Plate **Start Qty:** 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 13.09.24 NEW ISSUE DD VERF:JLM IPP REV:B 13.12.23 DWG REV.PB2 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174~~S12GA~~ 11GA 17-4 SS SHEET 0.099 - 0.114		Purchased	No				sf	2.0000		1 Q 13-12-27			

Location	Loc Qty	Loc Code
MAT019	2	
103905	2	

M127802 x 0.3

DART AEROSPACE LTD	Work Order:	110524
Description: Mount (Plate)	Part Number:	D4950-1
Inspection Dwg: D4950 Rev: PB2		Page 1 of 1

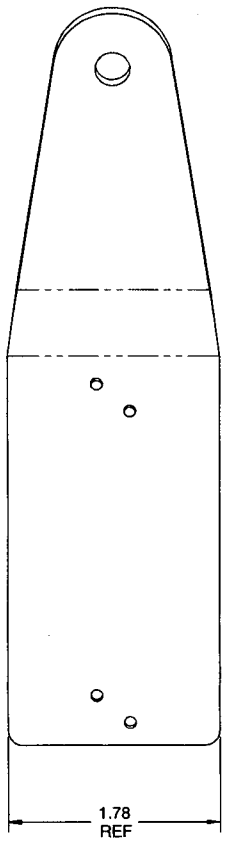
FIRST ARTICLE INSPECTION CHECKLIST

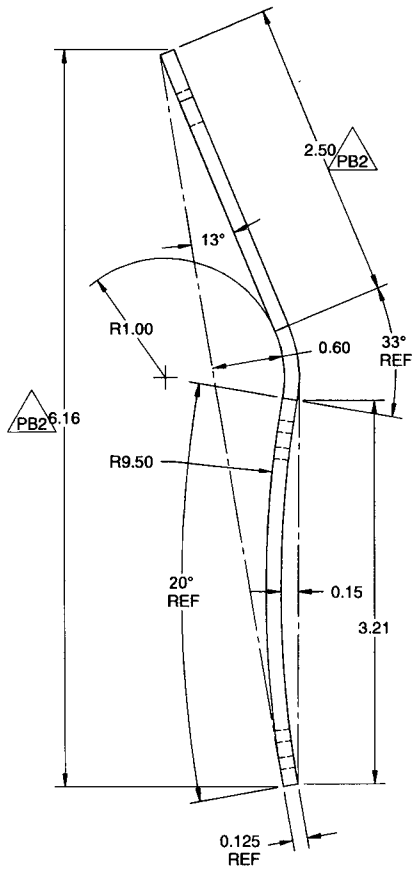
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.295	+/- 0.0006 0.0001	0.297	✓	U	JKM05	
1.78	+/- 0.03	1.789	✓			
Ø.098	+0.006 -0.001	1.00	✓			
0.0890	+/- 0.01	0.89	✓			
6.35	+/- 0.03	6.348	✓			
0.750	+/- 0.010	0.755	✓			
0.280	+/- 0.010	0.281	✓			
0.192	+/- 0.01	0.195	✓			
0.227	+/- 0.01	0.225	✓			
2.783	+/- 0.01	2.787	✓			
0.226	+/- 0.01	0.223	✓			
3.24	+/- 0.03	3.25	✓			
0.125	+/- 0.01	0.1245	✓			

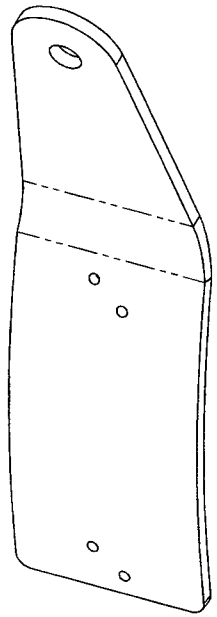
Measured by:		Audited by:	DAS 27 9-89	Preliminary Approval:	
Date:	13-12-27	Date:	15/01/07	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15







110524 MCJ
13-12-23

D4950-1 MOUNT

NOTES:
1) MATERIAL: MAKE FROM D4950-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.35 lbs

WORK IN PROGRESS

DESIGN	DB	**DART AEROSPACE LTD**
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4950 — REV. PB2
MFG. APPR.	DD	SHEET 3 OF 6
APPROVED		TITLE: MOUNT — SCALE: NTS
DE APPR.		
DATE	13.12.11	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

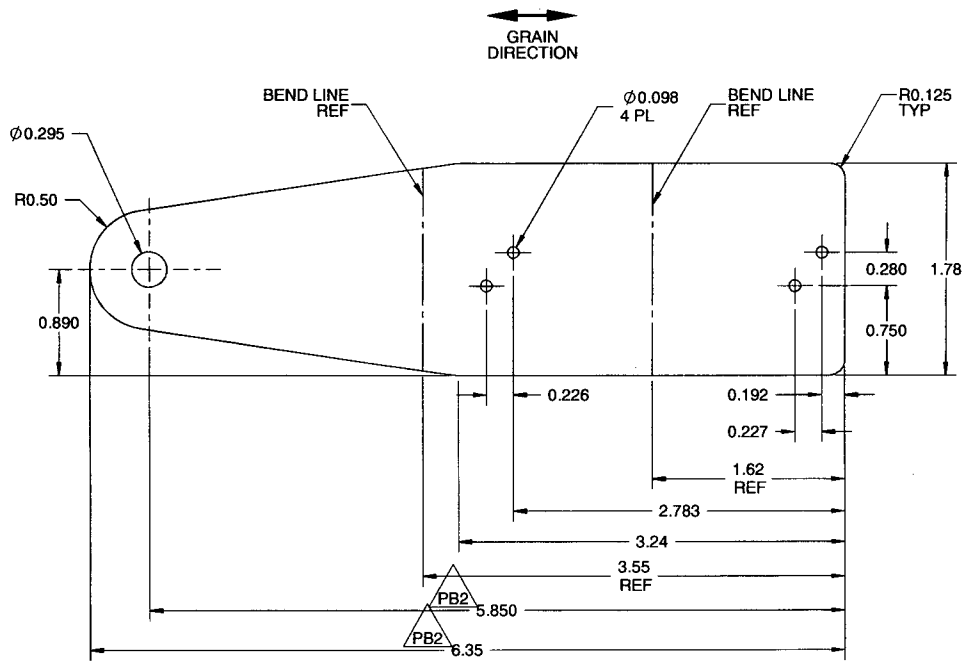
FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



D4950-1F FLAT PATTERN

13.12.23

NOTES:
1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 12 GA (0.125 THICK), PER AMS 5604 PB2
 MIN YIELD STRENGTH = 105 KSI
 MIN ULTIMATE STRENGTH = 135 KSI
 REF DART SPEC M17-4-S12GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.35 lbs

WORK IN PROGRESS

DESIGN	DB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	MB	
CHECKED	AP	DRAWING NO. D4950 REV. PB2
MFG. APPR.	DD	SHEET 4 OF 6
APPROVED		TITLE MOUNT SCALE NTS
DE APPR.		
DATE 13.12.11		

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DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

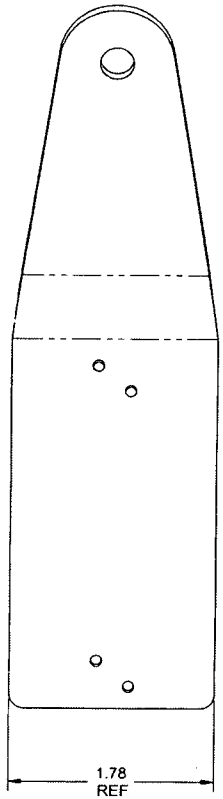
DART AEROSPACE LTD

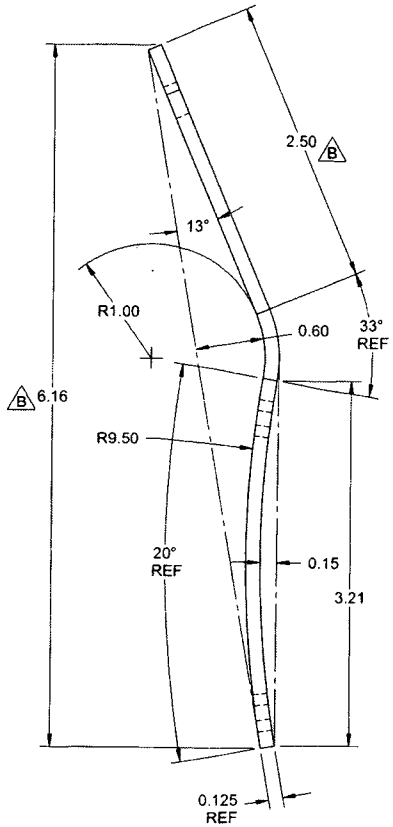
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Inspection Drawing: D4950	Rev: P6 2	Part Number:	D49504

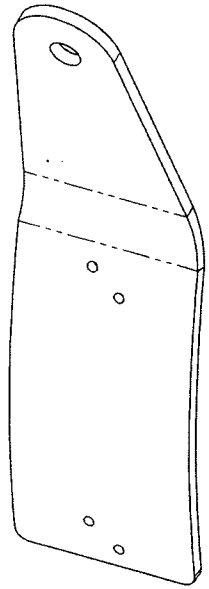
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-.030	2.50	✓		U	
.600	+/-.030	.590	✓		U	
.15	+/-.030	.145	✓		U	
3.21	+/-.030	3.21	✓		U	

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
DAS 30 9-89	DAS 36 9-89	DAS 27 9-89	
Date 14/01/07	Date 14/01/07	Date 14/1/7	Date







D4950-1 MOUNT

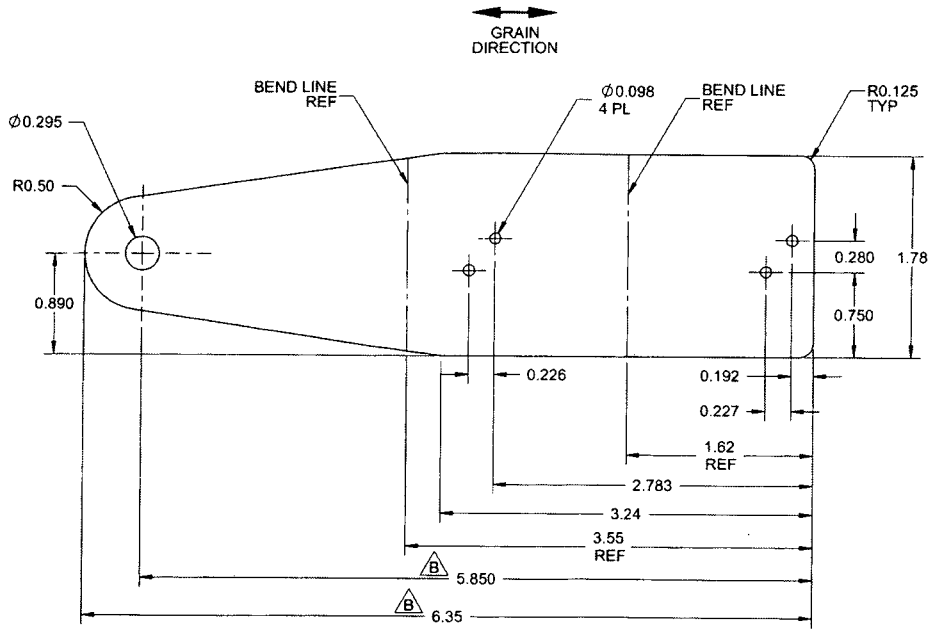
RELEASED
2014 -01- 15
MP

NOTES:
1) MATERIAL: MAKE FROM D4950-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.35 lbs

APPROVED

DESIGN	DB	**DART AEROSPACE LTD**
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4950 REV. B
MFG. APPR.	DD	SHEET 3 OF 6
APPROVED	MP	TITLE MOUNT
DE APPR.	DS	SCALE NTS
DATE	14.01.09	

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D4950-1F FLAT PATTERN

RELEASED
2014 -01- 15

NOTES:
1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 11 GA (0.125 THICK), PER AMS 5604 (B)
MIN YIELD STRENGTH = 105 KSI
MIN ULTIMATE STRENGTH = 135 KSI
REF DART SPEC M17-4-S11GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.35 lbs

APPROVED

DESIGN	DB	**DART AEROSPACE LTD**
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4950 REV. B
MFG. APPR.	DD	SHEET 4 OF 6
APPROVED	MP	TITLE MOUNT SCALE NTS
DE APPR.	DS	
DATE 14.01.09		

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